

Work Order ID 110374

December-17-13 9:24:32 AM

110374

Page 1

Item ID: D2535 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spring
 Start Date: 12/17/13 Start Qty: 20.00 **50**
 Required Date: 12/17/13 Req'd Qty: 20.00 ***20***
 Reference: ***20*** Cust Item ID:
 Customer:

Approvals: Process Plan: MLS Date: 13-12-18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2535	Rev A

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 82451 Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring
CL 13/12/19 (50)

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached
13/12/23 (50) L

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control Check dims to dwg
 DAS 27 9-89
14/1/17
50
com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 110374

110374

Page 2

December-17-13 9:24:32 AM

Item ID: D2535 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spring
 Start Date: 12/17/13 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>STO11</u>	0.00							
130									
Packaging	Memo	0.00				<u>50x</u>			<u>14-1-7</u>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							<u>14-01-1</u>
Quality Control									<u>2/01/14</u>

14-01-8

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

December-17-13 9:24:31 AM

Page 1

Work Order ID: 110374

Parent Item: D2535

Parent Item Name: Spring

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A99.04.19New Issue (From hand written IPP)DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2535P Spring		Purchased	No			100	Each	0.0000	1	20		12/17/23 (52)	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Process									
Supplier									
Training									
Transport									
Unapproved									

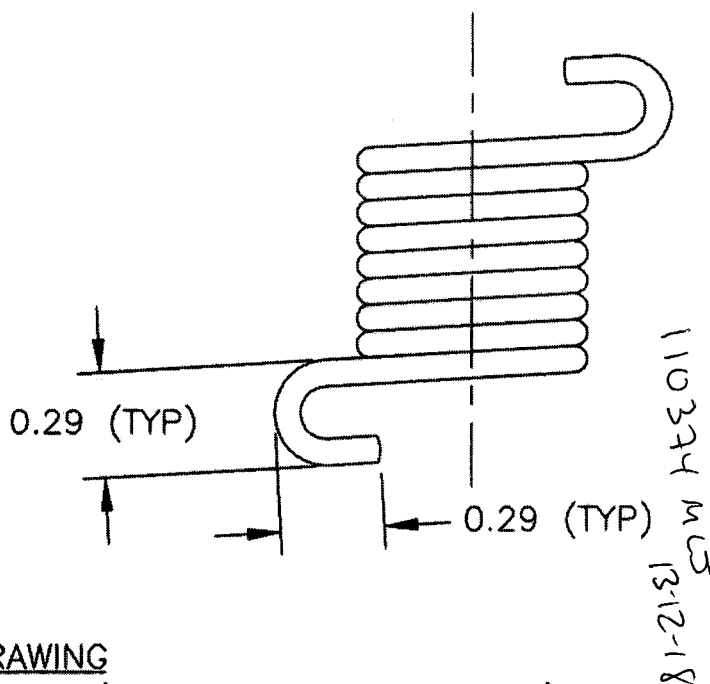
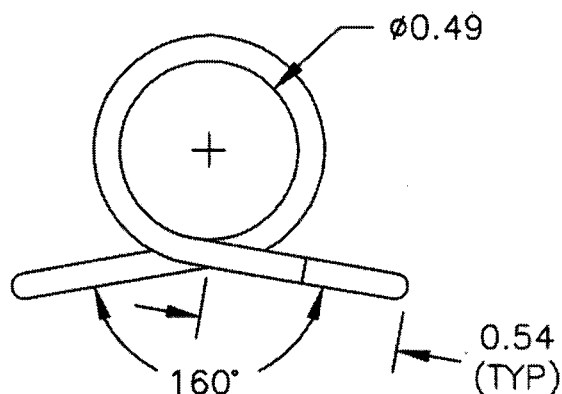
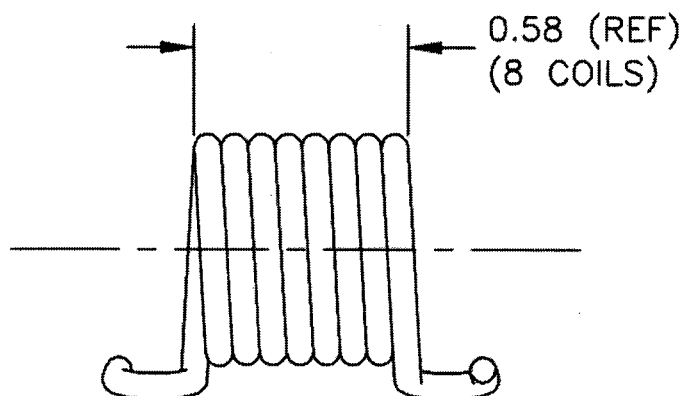
FAULT CATEGORY

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DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KE



SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22451

Purchase Order Date 12/19/2013

PO Print Date 12/19/2013

Page Number 1 of 1

Order From :

VC-VIC002

Ship To :

DART AEROSPACE LTD

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FX
2/3/2/RC

Contact Name

Vendor Phone 866 230 5312

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2535P	Spring	1/6/2014 Yes 1/6/2014		50.00 Each	\$4.56	\$228.00

AS PER DWG D2535 REV. A
B110374

Line Total: \$228.00

PO Total: \$228.00

CLML

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required - YES NO

PST# 6122-5207

Change Nbr:

1

Change Date:

12/19/2013



convenient. consistent. correct.

PACKING SLIP

28673

#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

BILL TO: Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

SHIP TO: Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

DATE		ORDER No.		SHIP VIA	
Dec 20, 2013		22451		FedEx	
QUANTITY	DESCRIPTION			UNIT	AMOUNT
50	VIC 1533 D2535P Spring - Torsion				
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd.	DATE: 12/20/2013
PART/DRAWING #: D2535P VIC 1533	PO # 22451
ALSCR: Torsion Spring	QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS302	yes	
Material diameter	0.07	0.072	
Coil I.D.	0.490	.492"	
Coil O.D.		.636"	
Number of Coils	8 ref	7.9	
Overall Length		1.12	
Coil Type	per dwg	yes	
Finish	RHW	RHW	

COMMENTS

Is Certificate attached: no
Material Heat Number: 35791

Inspected by: *Jeremy Burrowes*